

Amendments to the Specification

Please add the following paragraph between the second and the third paragraph on page 7 of the above-captioned patent application:

-- Figure 5 shows the progressive change in profile of the flat steel 43 as it moves through the roll forming apparatus. As shown by the profile marked "A," the steel is flat, and travels through a first set of rollers 42 in order to form a U-section profile "C." An intermediate profile "B" has been included to show the progressive change in profile from flat to a U-section profile. The swage rollers 46 introduce the ridges to form a profile marked as "D." Next, a first sub-set of rollers in the lip rollers 45 form a 45 degree lip to produce a profile marked as "E." Finally, the second sub-set of rollers in the lip rollers 45 output a C-section profile marked "F."

All of the steps A-F may be performed to produce a C-section profile, and the lip rollers 45 may be driven by a hydraulic motor away from the sheet, such that only steps A-D are performed to produce a U-section profile.--